

Work Order ID 82327

82327

Page 1

March-28-12 4:03:13 PM

Item ID: D3912-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eyebolt Receiver Assembly
 Start Date: 28/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3912	B

100	Pick Kit	0.00
100		
Packaging	Memo	0.00
Packaging		

Signature 12/04/03 (C)

110		0.00
110		
Small Fab	Memo	0.00
Small Fab	1-Assemble D3912-1/-3/-5 and install rivets as per dwg TRIM RIVETS 1.250" LONG	
	2- Install helical, spring plunger and spring pin lanyard assy as per dwg	

Signature 12/04/03 PJD

120	QC5- Inspect part completeness to step on W/O	0.00
120		
QC	Memo	0.00
Quality Control		

Signature

(C)

W/O: 82327

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3912-041 PAR #: _____ Fault Category: Small PAB NCR: Yes No DQA: AKL Date: 12/04/08
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AK Date: 12/4/10

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/08	10	7 Delivered MS 21208 FG-15 were scrap traced was not well done R.C process	S 12/04/08 AST412	Scrap - destroy replace scrap batch #120007	S 12/04/08	S 12/04/08	S AST412	S 12/04/08

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: ST 507	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

4X **SP 12-04-04**

12/4/4

12-04-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82327

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Parent Item: D3912-041

D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R		Purchased	No				Each	194.0000		4			
NAS1149C.0663R									**				
Washer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST297				194					
					116893			194					
D3912-1		Manufactured	No			100	Each	20.0000	1	4			
D3912-1									**				
Eyebolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG091				-12					
					69593			0					
				ST070				20					
					77073			12					
					77552			8					
				ST091				12					
D3912-3		Manufactured	No			100	Each	6.0000	2	8			
D3912-3									**				
Eyebolt Block													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST070				6					
					77554			6					

382640

8a

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 82327

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Parent Item: D3912-041

D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 4.00

Required Qty: 4.00

D3912-5 Manufactured No

100 Each 16.0000 2 8

D3912-5

Eyebolt Plate

**

EB 12/04/03

Location

Loc Qty

Loc Code

ST070

16

76961

3

81458

13

D3801-1 Manufactured No

Each 14.0000

D3801-1

Hand Retractable Spring Plunger

**

EB 12/04/03

Location

Loc Qty

Loc Code

GA

4

80996

4

ST064

10

75178

10

MS20615-4M20 Purchased No

100 Each 106.0000 8 32

MS20615-4M20

RIVET

**

EB 12/04/03

Location

Loc Qty

Loc Code

FP

50

120644 -

50

GA

56

119546

26

119638

30

18
14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 82327

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

82327

D3912-041

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 4.00

Required Qty: 4.00

MS21209-F615

Purchased

No

Each

62.0000

MS21209-F615

Heli-Coil

**

4

Location

Loc Qty

Loc Code

ST304

18

108170

11

108244

7

ST305

44

108170

0

108244

0

120072

44

4
PB 12/04/13
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

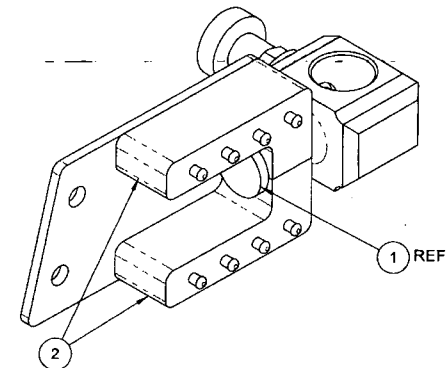
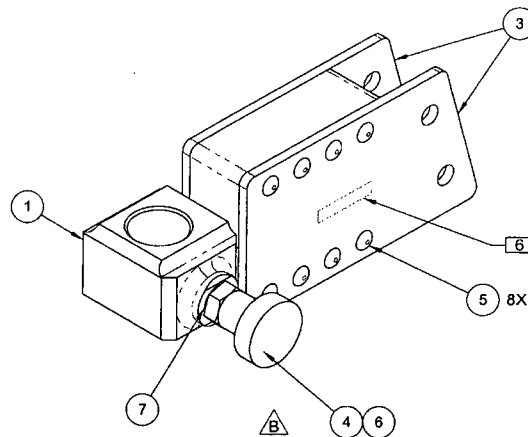
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82327 MCT
12/03/29

SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

RELEASED
2010-07-16

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AS		
DRAWN	AS		
CHECKED	AS		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS		
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3912 REV. B
SHEET 1 OF 3

TITLE EYEBOLT RECEIVER ASSY SCALE NTS

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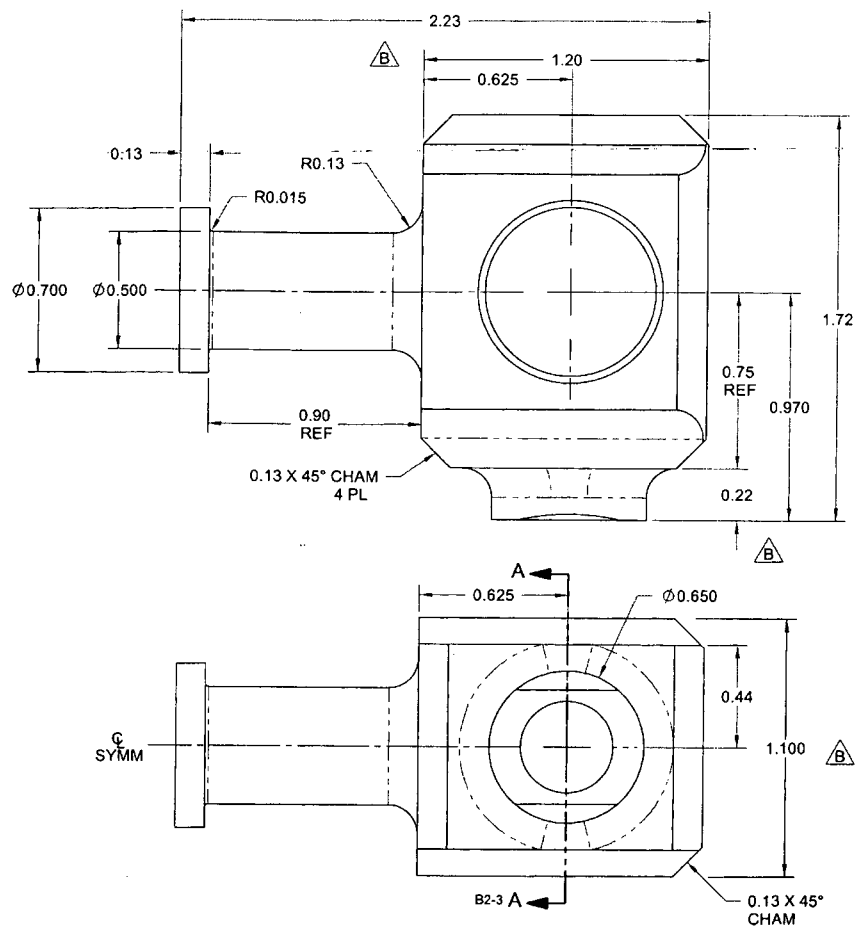
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

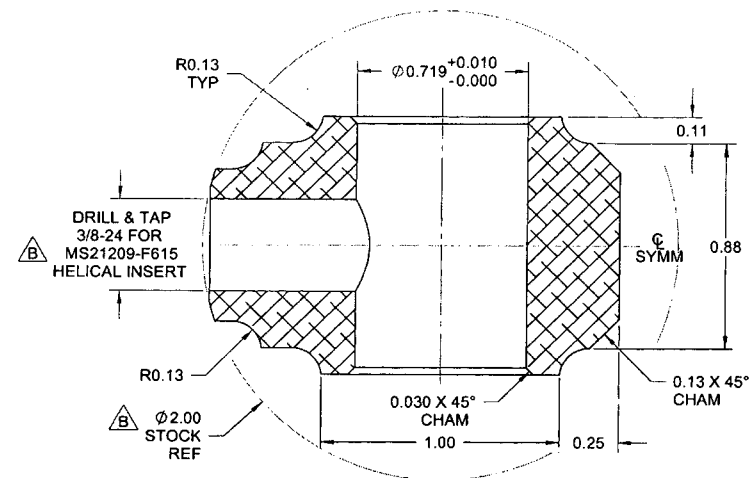
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	ALS	D3912	SHEET 2 OF 3
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

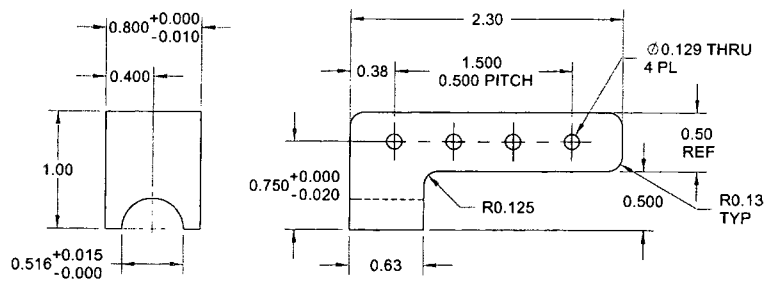
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

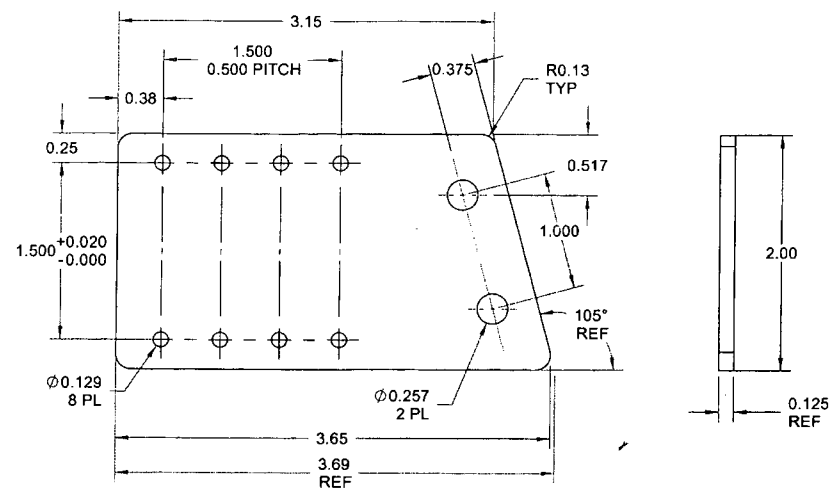
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82327



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-8059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ID AT ASSEMBLY

7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
md

DESIGN	<i>A/S</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D3912	SHEET 3 OF 3
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	EYEBOLT RECEIVER ASSY	NTS
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